

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029890**Date Inspected:** 28-Jul-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** IERBYS Bldg.**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Womens Rest Room Counter**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Oakland in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

This QA Inspector randomly observed the fit up and installation of two (2) 2x4 HSS steel beams for the counter support in the womens rest room of the IERBYS Building. This QA Inspector randomly observed the ABF/JV welder, Donald Plumb #0891, perform the Flux Core Arc Welding (FCAW) of the Partial Joint Penetration (PJP) joints of the counter support beams. The welder was observed utilizing the WPS ABF-D1.5-F2200 which was also used by the QC inspector, Salvador Merino, to monitor the welding operation of the following; the fit-up, the preheating of the surface area prior to welding and the welding parameters which were recorded as follows; 220 amperes and 21 volts. This QA Inspector made subsequent observations throughout the shift to monitor the work and the inspection performed by Mr. Merino. The work was completed on this date and appeared to be in general conformance with the contract documents.

This QA observed QC Inspector Salvador Merino perform the inspection using the following Non-Destructive Testing methods; Visual Testing (VT) and Magnetic Particle Testing (MPT). The QC inspector was observed performing the inspection and testing as per the contract specifications. Unless otherwise noted, all work observed on this date appeared to generally be in compliance with the contract documents.

**Summary of Conversations:**

Conversations on this date were relevant to work performed.

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## WELDING INSPECTION REPORT

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Frey,Doug	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes,Danny	QA Reviewer

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